



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3913-041
Job Sheet 174785



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/13/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-4-17
100	Large Fab	1 pcs		4/14/18	0.00	10.00	Large Fab 1		18-4-20
110	QC	1 pcs		4/14/18	0.00	0.00	QC9		18-05-01
120	QC	1 pcs		4/14/18	0.00	0.00	QC5		18-05-01
125	HandFinish	1 pcs		4/14/18	0.00	0.29	HandFinish2		18-5-01
130	Powdercoat	1 pcs		4/14/18	0.00	0.93	Powdercoat2		18-5-01
135	Packaging	1 pcs		4/14/18	0.00	0.00	Packaging1		18-5-01
140	QC	1 pcs		4/14/18	0.00	0.00	QC3		18-5-02
150	HandFinish	1 pcs		4/16/18	0.00	0.50	HandFinish4		18-5-02
160	QC	1 pcs		4/16/18	0.00	0.00	QC5		18-5-2
170	Packaging	1 pcs		4/16/18	0.00	0.00	Packaging3-2		18-5-02
180	QC21-SA	1 Ea		4/16/18	0.00	0.00	QC21		21 MAY 18 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138260 START: 3:40. O.V.T. 375° FINISH: 3:55.

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5049419
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5043834
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5048304
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5054823
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5053542
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5052685
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5053698
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5036080
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5045854
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5053103
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5049913
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5049859
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5051470
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5052649
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054963
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5049718
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041479
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	506435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042691
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5062373
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5057525
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5054025
002079				
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	54	0
	D3913-1	1	13	0
	D3913-15	1	15	0
	D3913-3	1	5	0
	D3913-7	2	11	0
	D3913-9	1	1	0
	D3916-041	2	12	0
	D3916-5	3	9	0
	D4016-1	3	16	0
	D4017-7	3	45	0
	D4017-9	2	12	0
	D4020-11	2	22	0
	D4021-1	3	16	0
	D4034-041	1	6	0
	D4034-043	1	9	0
	D4672-1	2	8	0
	M304EX0.75-16F	33	821	0
	AN3-10A	6	273	0
	D2931	2	1,108	0
	D4021-5	2	24	0
150-HandFinish	MS20600-AD4W3	2	213	0
	MS21042L3	6	2,700	0
	NAS1149F0332P	12	2,125	0
Part Specifications				
Specifications could not be found.				

Plex 3/21/18 12:55 PM Dart.Gagnon.Michelle

Master Unit 002079



Job No 174785



Container No: S062036



Part: D3913 – 041

Job No: 174785

Serial No/Batch: S062036

Revision:

Inspector:

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